

Work Order ID ~~77316~~***77316***

Page 1

December-02-11 11:31:57 AM

Item ID: D3182-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Hinge

Start Date: 02/12/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 08/12/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: M.C.J.Date: 11/12/02 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3182

Rev A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3182 Dwg Rev: A Prog Rev: A 2-
Deburr if necessaryB11-12-5

(10)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B11-12-5

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

S 11/12/05

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77316

December-02-11 11:31:57 AM

77316

Page 2

Item ID: D3182-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hinge
 Start Date: 02/12/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 08/12/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab Small Fab	Small Fab Memo Deburr if necessary	0.00 0.00							
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo *****STOCK IN BASKET CELL*****	0.00 0.00							

Paul/12/11 (10)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

December-02-11 11:31:57 AM

77316

N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 02/12/2011 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 08/12/2011 **Req'd Qty:** 4.00 *** / ***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

0.00


160

QC

Memo

0.00

Quality Control

Number Stamp
11/12/13 

ms
11-12-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

December-02-11 11:32:01 AM

Page 1

Work Order ID: 77316

77316

Parent Item: D3182-1

D3182-1

Parent Item Name: Hinge

Start Date: 02/12/2011

Required Date: 08/12/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A03.01.29New issueKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA *M304S11GA* 304/316 0.125 Sheet		Purchased	No			100	sf	68.4000	0.0596	0.250947	1		
**										B11-10-5			

Location	Loc Qty	Loc Code
MAT020	68.4	
119006	32.5	
119048	35.9	

119048

10

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Dart Aerospace Ltd

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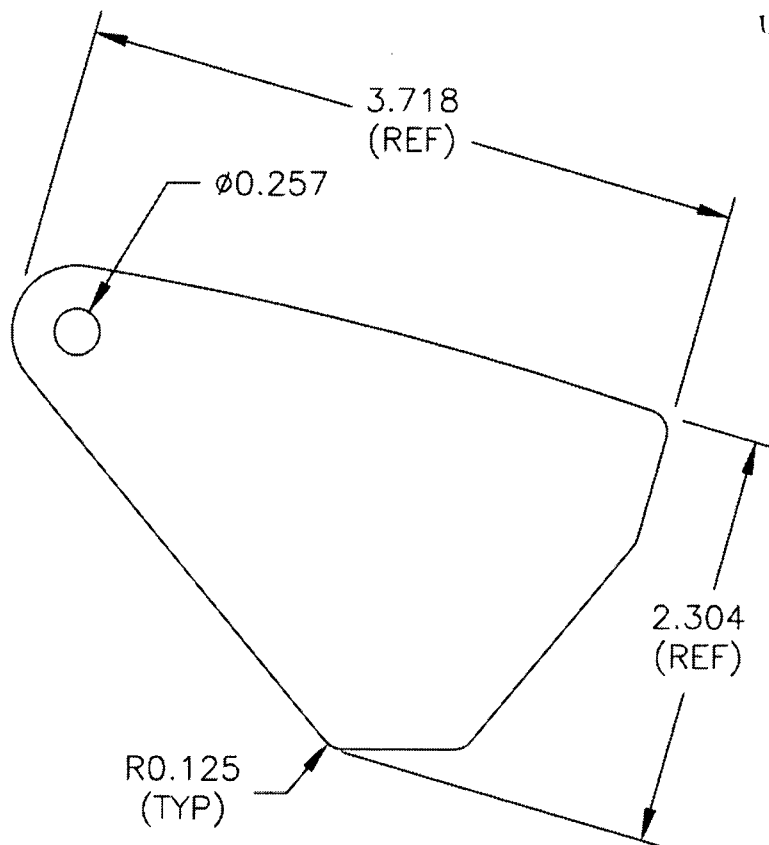
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DESIGN A	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED A	APPROVED A	DRAWING NO. D3182	REV. A SHEET 1 OF 1
DATE 03.01.21		TITLE HINGE	SCALE 1:1
A	03.01.21	NEW ISSUE	

RELEASED
03.01.21



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77316
M.L.S.
11/12/02

D3182-1 HINGE

- 1) MACHINE D3182-1 PER DART DWG "D3182-1.DWG"
- 2) MATERIAL: AISI 304/316 SS SHEET 0.125 THICK
(REF DART SPEC. M304S11GA)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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